

Date: Wednesday, 2/15/2006 3:50:43 PM
 User: Kim Johnston

Process Sheet

| | |
|--|--|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : 206/OH-58 SADDLE, OUTBOARD, RIGHT SIDE |
| Job Number : 25871 | |
| Estimate Number : 10832 | |
| P.O. Number : N/A | Part Number : D29322 |
| This Issue : 2/15/2006 S.O. No. : N/A | Drawing Number : D2932 REV B |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : N/A Type : MACHINED PARTS | Drawing Revision : B |
| Previous Run : 25375 | Material : N/A |
| Written By : <i>See comment below</i> | Due Date : 3/15/2006 Qty: 4 Um: Each |
| Checked & Approved By : <i>JA 06.02.16</i> | |
| Comment : Est: B 00.06.26 New DWG rev (mmp 2069) EC | |

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

D6101003

7075-T7351 2X6.25X7.875



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

7075-T7351 2X6.25X7.875

Issue material from stock: 7075-T7351 (QQ-A-250/12)

Cut Size 2.0 x 6.25 X 7.88

Grain Along Long 7.88 Length

Batch No: *B 25347**J.L. 06.04.17*

2.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program part number and batch number.

1-Inspect part number and batch number are programmed correctly.

2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet

5-Deburr

J.L./SD 06.04.18

3.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

J.L./SD 06.04.18

4.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

J.L./SD 06.04.18

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/08/17
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|----------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 06.04.18 | 2.4 | Part pulled up while machining | | | SA 06.04.18 | | | |
| | | | | | | | | |
| | | | | | | | | |

Next page.

NOTE: Date & initial all entries

Date: Wednesday, 2/15/2006 3:50:43 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, OUTBOARD, RIGHT SIDE

Job Number: 25871

Part Number: D29322

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

En 06/06/02

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FC 06/08/11 (4)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Q.M. 06-08-16

(4)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

AB 06/02/16 (4)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST474

AB 06/08/16 (4)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

CD 06/08/17

Job Completion

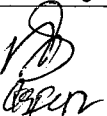
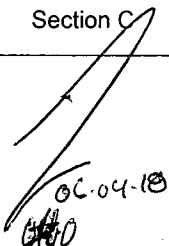

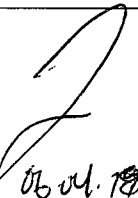


C 206/08/17

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|---|---|---------------------------------|----------------|--|--|--|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | 2.4 | 1 part scrap. Pulled up while machining, on the 4 bottom holes. Damage .055 deep. |  | Scrap & replace | SD 06.08.13 |  06.04.13 |  06.04.13 |  06.04.13 |
| | 2.0 | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | |
|--|-----------------------------|
| DART AEROSPACE LTD | Work Order: 25871 |
| Description: 206 Saddle, Outboard, Right side | Part Number: D2932-2 |
| Inspection Dwg: D2932 Rev. B | Page 1 of 1 |

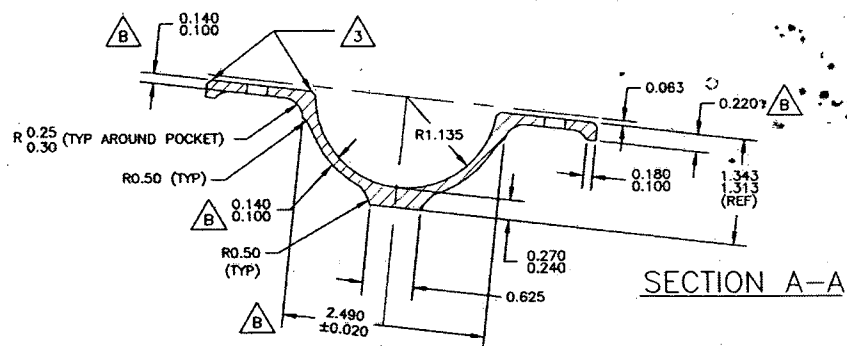
Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. B and record below:

| | | | | Recorded Actual Dimensions | | | | | |
|---------------|-------|-------|----------------|----------------------------|-------|-------|-------|----|------|
| Dim | Min | Max | Go/No Go Gauge | 1 | 2 | 3 | 4 | By | Date |
| A | 0.100 | 0.140 | | .125 | .126 | .125 | .125 | | |
| B | 0.100 | 0.140 | | .125 | .125 | .125 | .126 | | |
| C | 0.100 | 0.140 | | .130 | .130 | .130 | .130 | | |
| D | 0.210 | 0.230 | | .221 | .221 | .221 | .221 | | |
| E | 1.245 | 1.255 | | 1.250 | 1.251 | 1.250 | 1.250 | | |
| F | 1.245 | 1.255 | | 1.250 | 1.250 | 1.250 | 1.250 | | |
| G | 2.495 | 2.505 | | 2.500 | 2.501 | 2.500 | 2.500 | | |
| H | 0.510 | 0.515 | | .514 | .514 | .514 | .514 | | |
| I | 1.572 | 1.582 | | 1.577 | 1.577 | 1.577 | 1.577 | | |
| J | 2.495 | 2.505 | | 2.500 | 2.500 | 2.500 | 2.500 | | |
| K | 0.257 | 0.262 | DT8683 | ✓ | ✓ | ✓ | ✓ | | |
| L | 0.312 | 0.317 | DT8686 | ✓ | ✓ | ✓ | ✓ | | |
| M | 0.235 | 0.240 | | .238 | .238 | .238 | .238 | | |
| N | 0.100 | 0.140 | | .115 | .115 | .116 | .116 | | |
| O | 0.540 | 0.560 | | .548 | .549 | .546 | .548 | | |
| P | 0.490 | 0.510 | | .500 | .500 | .499 | .495 | | |
| Q | 3.715 | 3.725 | | 3.720 | 3.719 | 3.720 | 3.720 | | |
| R | 2.470 | 2.510 | | 2.496 | 2.496 | 2.496 | 2.499 | | |
| S | 0.240 | 0.270 | | .253 | .252 | .253 | .253 | | |
| T | 0.100 | 0.180 | | .143 | .143 | .143 | .143 | | |
| U | 1.625 | 1.635 | | 1.630 | 1.631 | 1.629 | 1.629 | | |
| V | 1.362 | 1.372 | | 1.367 | 1.366 | 1.367 | 1.367 | | |
| W | 0.316 | 0.321 | DT8690 | ✓ | ✓ | ✓ | ✓ | | |
| X | 1.125 | 1.145 | | 1.136 | 1.136 | 1.136 | 1.136 | | |
| Y | 1.565 | 1.585 | | 1.574 | 1.574 | 1.574 | 1.574 | | |
| Z | | | | | | | | | |
| AA | | | | | | | | | |
| AB | | | | | | | | | |
| AC | | | | | | | | | |
| AD | | | | | | | | | |
| AE | | | | | | | | | |
| AF | | | | | | | | | |
| AG | | | | | | | | | |
| AH | | | | | | | | | |
| Accept/Reject | | | | | | | | | |

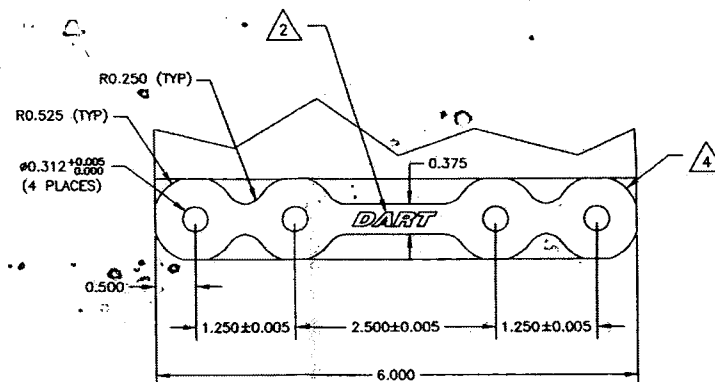
| | |
|--------------|----------|
| Measured by: | J-L / SD |
| Date: | 06-04-18 |

| | |
|-------------|----------|
| Audited by: | me |
| Date: | 06-06-18 |

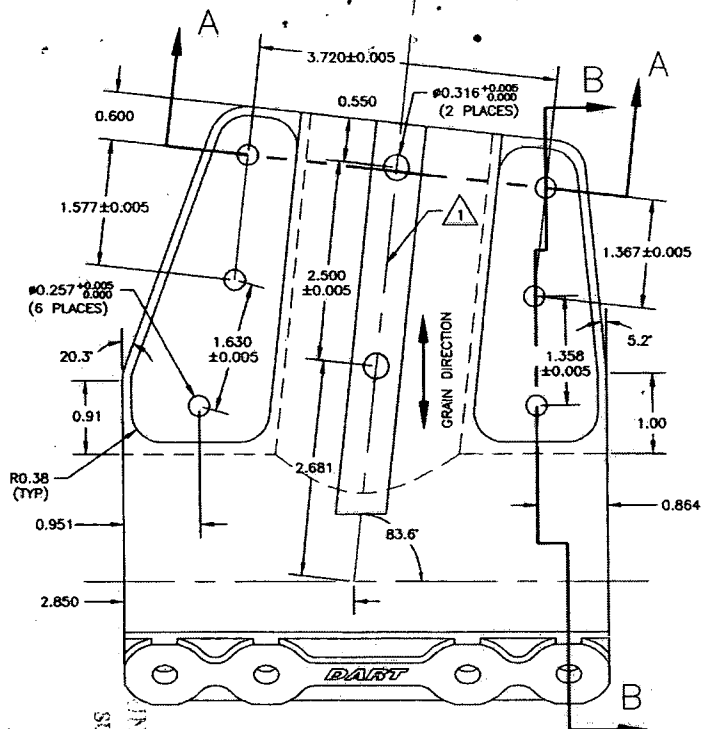
| Rev | Date | Change | Revised by | Approved |
|-----|----------|---|------------|----------|
| A | | New Issue | RF | |
| B | 02.12.12 | Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 | KJ/RF | |



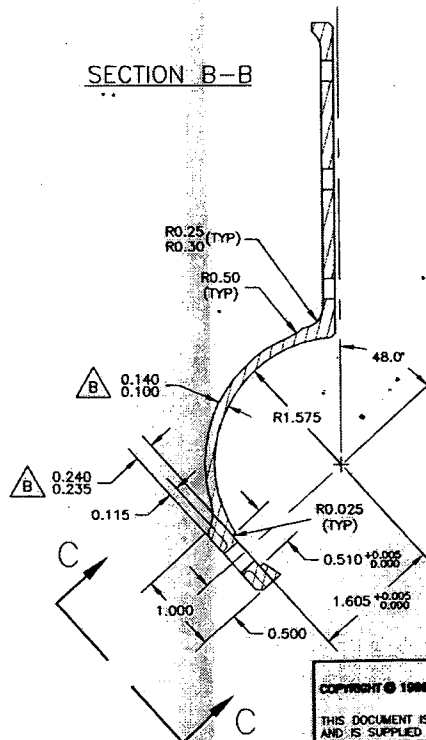
SECTION A-A



VIEW C-C



SECTION B-B



D2932-1 LH SADDLE (SHOWN)
D2932-2 RH SADDLE (OPPOSITE)

MATERIAL: 7075-T7351 (QQ-A-250/12)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP
- 2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.005 WITH MIN RAD 0.250
- 3 CHAMFER 0.050" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 4 CHAMFER 0.050" x 45°

RELEASED
00.05.29



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WITHOUT NOTICE
WORK ORDER
NO. 25871

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| | | |
|---------|----------------|--|
| B | 00.05.29 | CHANGED GEOMETRY AND MATERIAL |
| A | 99.10.29 | NEW ISSUE |
| DESIGN | DRAWN BY RF | DART DART AEROSPACE USA, INC. BELLINGHAM, WA |
| CHECKED | APPROVED | DRAWING NO. D2932 |
| DATE | 00.05.29 | TITLE SADDLE OUTSIDE |
| | | REV. B SHEET 1 OF 1 SCALE 2:3 |

